

Work Order ID 130126

Tuesday, February 24, 2015 8:45:12 AM

130126

Page 1

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: ML5 Date: 1502-24 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2750-042	G
D3492	C

100 Document Control 0.00

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

record fwd angle: 89°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAB
27
9-20

APR 22 2015

68-6
90
SVD

15-3-9
MLH

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Page 2

Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

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Stop ***NS2***

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Start Date: 2/24/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

110

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.

6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

7- Open up holes of Detail J to 0.297" (total of 2 holes per side)

8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

DGL 15-3-9

DGL 15-3-9

15-3-10

BK 15-03-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 3

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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.
 Start Date: 2/24/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/24/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	A/R Aluminum Rod batch: <i>ML30812</i>								
	9- Grind welds flush as per Dwg D2750								
120 *120* QC Quality Control	QC10- Inspect visual per QSI004- ground welds	0.00							<i>15-10</i> <i>15-3-10</i> <i>DAB</i> <i>9</i> <i>9-89</i>
	Memo	0.00							
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O ✓	0.00							<i>15-3-10</i> <i>DAB</i> <i>9</i> <i>9-89</i>
	Memo	0.00							

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130126***130126***

Page 4

Tuesday, February 24, 2015 8:45:12 AM

Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

15-3-10

JGC

15-3-10

JH

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
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Start Date: 2/24/2015 Start Qty: 1.00 ***1*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160									
Skidtubes	Memo	0.00							
Skidtubes	1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float holes using uni-bit to .500" (4 per Side)								
	4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5- Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7- Bond web D2739 in place as per OSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: <u>131574</u> exp. date: <u>15-10-21</u>								
	ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & OSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>M230812</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								

DGL 15-3-10

DGL 15-3-10

78E 15-03-11

15-3-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Quality Control

DAS
38
9-89

15-03-30

DAS
38
~~6-69~~

15-03-38

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Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 130126

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Item ID: D350-636-012

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.00							
Hand Finishing	Memo								
	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: <u>M113157J</u>								
	EXP DATE: <u>12/16</u>								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: <u>M4131349</u> RT0598 M125792 exp 15/16								
	5-Coat all exposed fasteners with "LPS Procyon"								
	batch: <u>M1122900</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	0.00							
Quality Control	Memo								

DAS

38

9-89

APR 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Crosstube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130126

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Item ID: D350-636-012 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.
Start Date: 2/24/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/24/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								

DAG
27
9-89
APR 21 2015

APR 22 2015

DAG
66
9-89

DAG
66
9-89

15-04-22

Work Order ID 130126

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Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/24/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MLJ 15-04-23

HS-4-22

Tuesday, February 24, 2015 8:45:16 AM

Required Qty: 1.00

IPP REV:K

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT-RH		Manufactured	No			110	Each	0.0000	1	1			
D2600-3-BENT-RH													
Extrusion Bent RH													
D2744		Manufactured	No			110	Each	40.0000	1	1			
D2744													
Cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG001				40					
				128212				40					
D2739		Manufactured	No			160	Each	1.0000	1	1			
D2739													
350 I Beam													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG				1					
				129054				1					

Picklist Print

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Page 2

Work Order ID: 130126

130126

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2743 Manufactured No 160 Each 62.0000 8 8

D2743

Crossbolt Spacer

**

BE 15-03-11
B 129465 x2

Location

Loc Qty

Loc Code

LG001

62

128943

62

D3490-3 Manufactured No 160 Each 43.0000 4 4

D3490-3

Cross Bolt Spacer

**

BE 15-03-11

Location

Loc Qty

Loc Code

LG001

43

129055

43

D3490-1 Manufactured No 160 Each 45.0000 4 4

D3490-1

Cross Bolt Spacer

**

BE 15-03-11

Location

Loc Qty

Loc Code

LG001

45

128984

45

D3631-1 Manufactured No 230 Each 182.0000 8 8

D3631-1

Washer

**

all 1510412

Location

Loc Qty

Loc Code

FP001

182

128320

82

128910

100

B 129928

x 8

Picklist Print

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Work Order ID: 130126

130126

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

30.0000

1

1

D3791-1

Wearpad

**

all 1510415

Location

Loc Qty

Loc Code

FP002

30

125913

11

126317

19

X1

D3793-3

Manufactured No

230

Each

25.0000

1

1

D3793-3

Wearplate Aft

**

all 1510415

Location

Loc Qty

Loc Code

FP002

25

125915

11

128236

14

X1

MS21043-6

Purchased No

230

Each

170.0000

4

4

MS21043-6

NUT

**

all 1510415

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

50

m130325

2

m130726

48

ST304

100

131618

100

X4

Picklist Print

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Page 4

Work Order ID: 130126

130126

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230

Each

32.0000

1

1

D3794-1

Gasket Fwd

**

all 15/04/15

Location

Loc Qty

Loc Code

FP001

32

125916

6

128238

26

NAS1611-010

Purchased No

230

Each

300.0000

8

8

NAS1611-010

O-RING

**

all 15/04/15

Location

Loc Qty

Loc Code

FP001

300

m130797

4

m131329

96

m131618

200

Y1130776

Y8

D2741

Manufactured No

250

Each

11.0000

1

1

D2741

Replacement Blade

**

DAS

27

9-89

APR 21 2015

Location

Loc Qty

Loc Code

FG

10

100664

3

113640

2

115522

5

ST538

1

125892

1

B128088

1

DAS
86
9-89

Picklist Print

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Page 5

Work Order ID: 130126

130126

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1515H3L

Purchased

No

230

Each

539.0000

4

4

***NAS1515H3I ***

Washer

**

all stock

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

55

m127831

55

ST266

444

m127831

48

m130726

396

x 2

NAS1611-013

Purchased

No

230

Each

678.0000

8

8

NAS1611-013

O-RING

**

all stock

Location

Loc Qty

Loc Code

FP001

678

m130758

678

x 2

AN3C6A

Purchased

No

230

Each

440.0000

4

4

AN3C6A

Bolt

**

all stock

Location

Loc Qty

Loc Code

CA

39

m128704

39

FG

10

122416

10

ST338a

391

m128769

391

x 2

Picklist Print

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Work Order ID: 130126

130126

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

152.0000

1

1

NAS1149C0832R

Washer

all 12/04/15

Location

Loc Qty

Loc Code

FP001

8

m114915

8

ST271

144

m125807

144

VI

D3536-25

Manufactured

No

230

Each

18.0000

1

1

D3536-25

Gasket Center

all 12/04/15

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

12

125909

1

128578

11

B130140

VI

D3794-3

Manufactured

No

230

Each

68.0000

1

1

D3794-3

Gasket Aft

all 12/04/15

Location

Loc Qty

Loc Code

FP001

68

125917

4

127383

39

128239

24

92658

1

VI

Picklist Print

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Work Order ID: 130126

130126

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

953.0000

34

34

AN3C5A

Bolt

all 1510416

Location

Loc Qty

Loc Code

FG

5

122800

5

ST338a

526

M130770

10

M130851

16

M131320

500

X34

ST350

422

M131420

422

D3537-1

Manufactured

No

230

Each

139.0000

3

3

D3537-1

Wearpad

all 1510415

Location

Loc Qty

Loc Code

FG

18

79833

8

88562

10

FP001

121

125911

46

126306

1

127087

60

128225

14

B128762

X3

Picklist Print

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Page 8

Work Order ID: 130126

130126

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

66.0000

1

1

D3535-25

Wearplate Center

all stock

Location

Loc Qty

Loc Code

FG

2

95077

2

FP002

56

125908

15

128090

16

128224

25

FP007

8

127851

8

X1

D3492-3

Manufactured No

230

Each

245.0000

8

8

D3492-3

Plug

all stock

Location

Loc Qty

Loc Code

FP001

245

125905

2

128476

72

128914

171

D131036

X0

Picklist Print

Page 9

Tuesday, February 24, 2015 8:45:16 AM

Work Order ID: 130126

130126

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

230

Each

5,324.000

38

38

NAS1149C0332R

WASHER

all is/ok

Location

Loc Qty

Loc Code

FP001

2155

11131697

v38

m130325

2140

m130466

15

GA

2

125654

2

ST271

3167

125654

44

m131340

1123

m131618

2000

D3488-042

Manufactured

No

230

Each

7.0000

1

1

D3488-042

Blade Fitting RH

all is/ok

Location

Loc Qty

Loc Code

FP001

7

B128804

x1

125899

7

ALS4-1032-225

AELS8-1032-225 Purchased

No

230

Each

2,586.000

38

38

ALS4-1032-225

Rivnut

all is/ok

Location

Loc Qty

Loc Code

FG

120

M127028

120

FP001

41

M131067

41

st549

2425

M131582

2425

x38

Picklist Print

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Page 10

Work Order ID: 130126

130126

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3492-1

Manufactured No

230

Each

277.0000

8

8

D3492-1

Plug

**

all 15/04/15

Location

Loc Qty

Loc Code

FP001

277

128509

156

128955

121

x8

D3793-1

Manufactured No

230

Each

28.0000

1

1

D3793-1

Wearplate Fwd

**

all 15/04/15

Location

Loc Qty

Loc Code

FP002

28

125914

18

128235

10

x1

AN8C35A

Purchased No

230

Each

5.0000

1

1

AN8C35A

Bolt

**

all 15/04/15

Location

Loc Qty

Loc Code

FG

5

121275

5

M131947

x1

MS21083C8

Purchased No

230

Each

135.0000

1

1

MS21083C8

Nut

**

all 15/04/15

Location

Loc Qty

Loc Code

ST299

100

m131618

100

ST300

35

m131049

35

x1

Picklist Print

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Work Order ID: 130126

130126

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230

Each

199.0000

8

8

D2745

Bushing

**

all 25 locs

Location

Loc Qty

Loc Code

FP001

18

128920

18

B129584

x d

ST010

100

128480

100

ST012a

81

128089

81

AN6C44A

Purchased No

230

Each

146.0000

4

4

AN6C44A

Bolt

**

all 15 locs

Location

Loc Qty

Loc Code

FG

2

103964

2

M131856

x f

FP001

5

m130863

4

m131367

1

ST286A

13

m130863

13

ST332

11

m130863

11

ST333

115

m131151

50

m131546

65

Picklist Print

Tuesday, February 24, 2015 8:45:16 AM

Work Order ID: 130126

130126

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3532-1	Manufactured	No	250	Each	42.0000	2	2	DAS 27 9-89
D3532-1								
Spacer								

**

Location

Loc Qty

Loc Code

ST048

42

125907

2

128091

40

B128964

2

DAS
86
9-89

MS21083C8

Purchased

No

250

Each

135.0000

2

2

DAS
27
~~9-89~~

MS21083C8

Nut

**

Location

Loc Qty

Loc Code

ST299

100

m131618

100

ST300

35

m131049

35

2

DAS
86
9-89

NAS1149D0863J

Purchased

No

250

Each

718.0000

2

2

DAS
27
~~9-89~~

NAS1149D0863J

Washer

**

APR 21 2015

Location

Loc Qty

Loc Code

FP001

57

125484

57

ST260a

661

125268

561

125635

100

2

DAS
86
9-89

Picklist Print

Tuesday, February 24, 2015 8:45:16 AM

Work Order ID: 130126

130126

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.

Start Date: 2/24/2015

Required Date: 2/24/2015

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

146.0000

2

2

D3493-1

Washer

DAS
27
9-89

DAS
66
9-89

Location

Loc Qty

Loc Code

FG	10	
97201	10	
ST046	136	
125906	35	
128755	101	

2

***ONLY INSTALL IF INSTALLING ON APICAL
FLOAT SYSTEM***

AN8C21A

Purchased

No

250

Each

31.0000

2

2

AN8C21A

Bolt

DAS
27
9-89

DAS
66
9-89

Location

Loc Qty

Loc Code

FG	2	
123966	2	
ST332	29	
m131100	3	
m131547	26	

M/1886

2

APR 21 2015

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN8C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

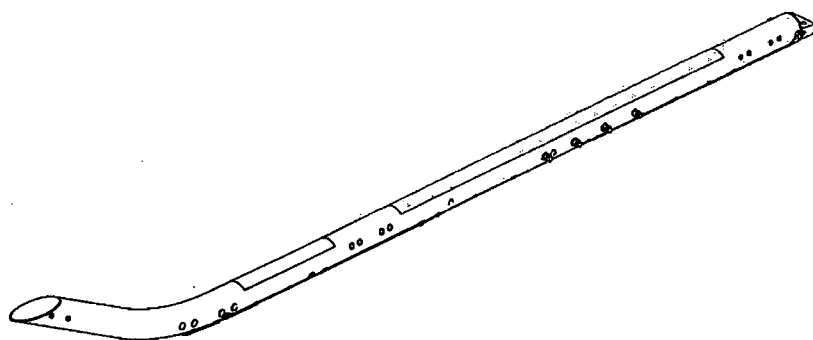
GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
 STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
 OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES (Ø0.297) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
 MINIMUM YIELD TENSILE STRENGTH = 35 KSI
 MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
- FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

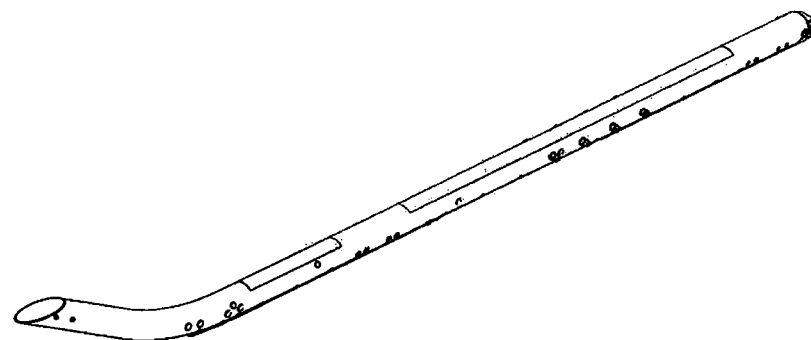
G	CORRECTED TOLERANCE ON Ø0.500 THRU HOLE: IS +0.010/-0.000, WAS +0.100/-0.000 (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL) WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741. QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEC 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	JB	KENT, WA	
CHECKED	JB	DRAWING NO.	REV. G
MFG. APPR.	JB	D2750	SHEET 1 OF 11
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	350 SKIDTUBE ASSEMBLY	NTS
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130126 MJS
1502-24

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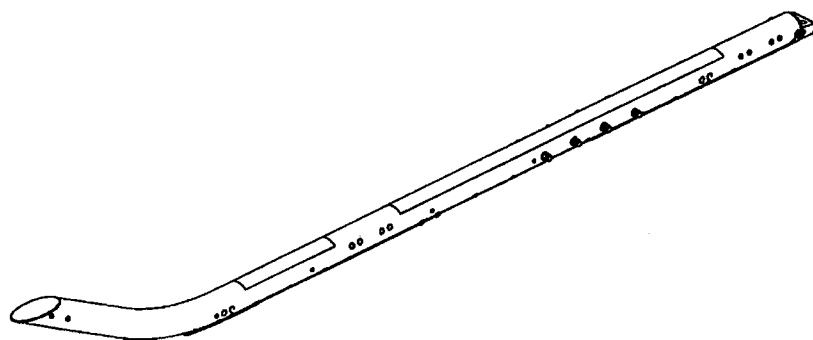
D2750-041 350 SKIDTUBE ASSEMBLY, LH



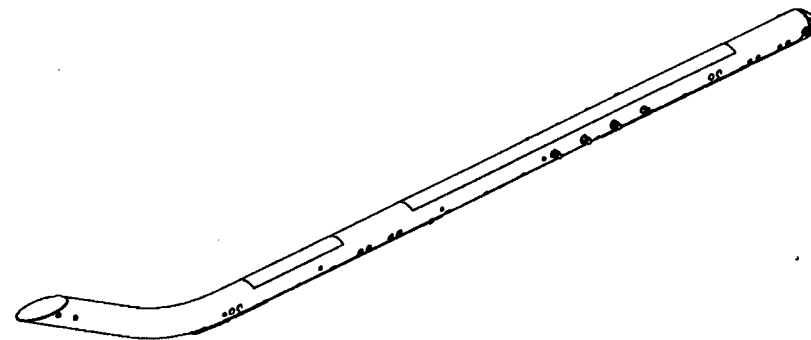
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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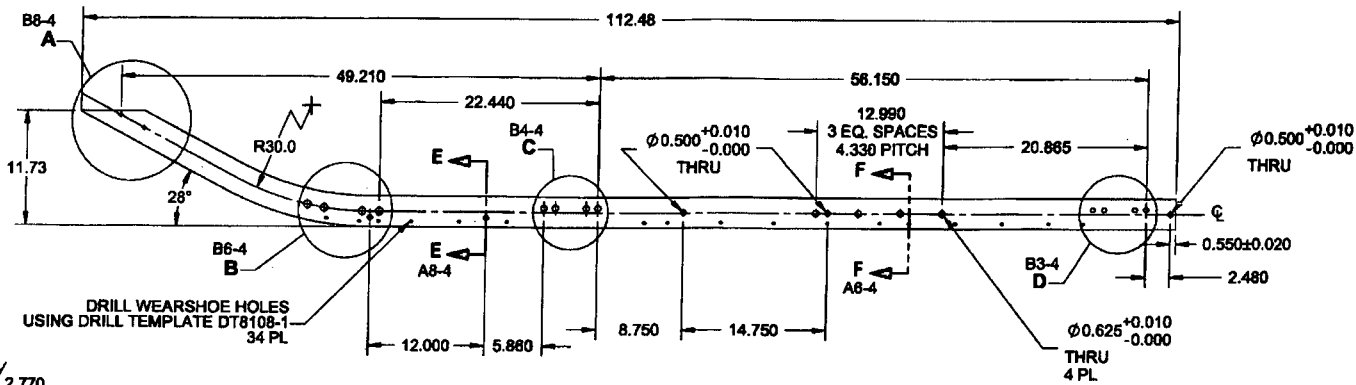
D2750-043 350 SKIDTUBE ASSEMBLY, LH



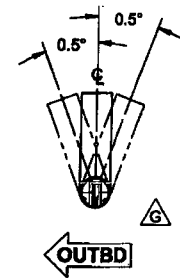
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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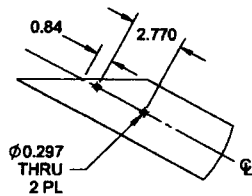
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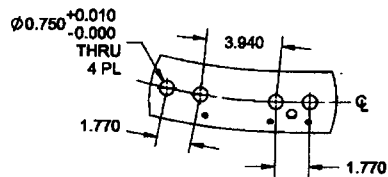
D2750-1 LH SKIDTUBE



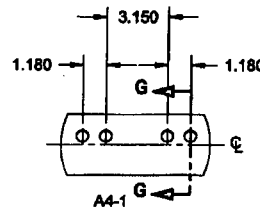
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



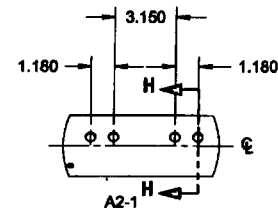
DETAIL A
SCALE 2X



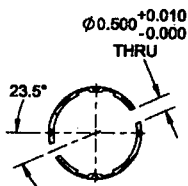
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SCALE 2X



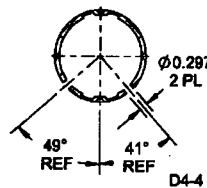
DETAIL C
SCALE 2X



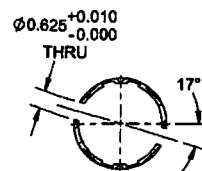
DETAIL D
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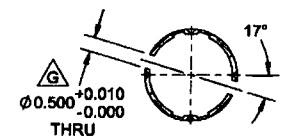
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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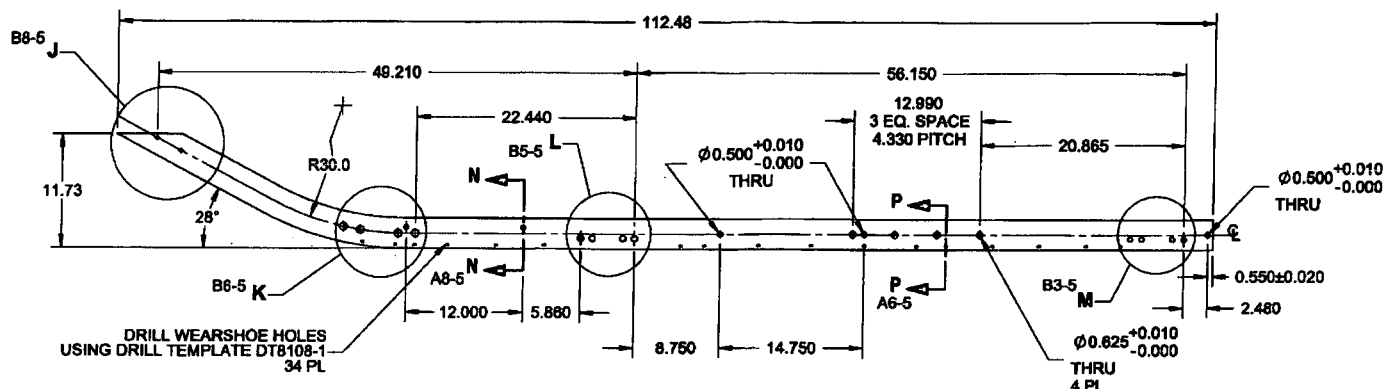
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TITLE
350 SKIDTUBE ASSEMBLY

REV. G
SHEET 4 OF 11
SCALE
NTS

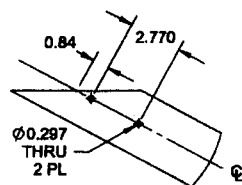
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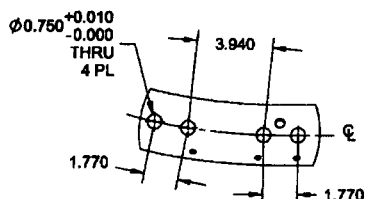
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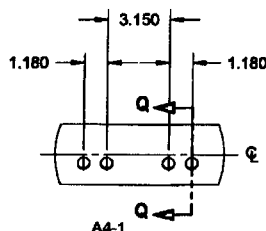
D2750-2 RH SKIDTUBE



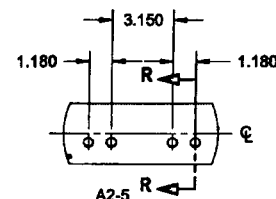
DETAIL J
SCALE 2X



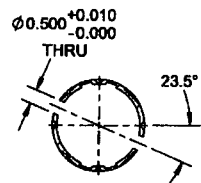
DETAIL K
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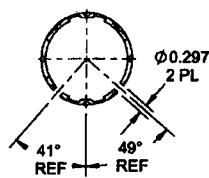
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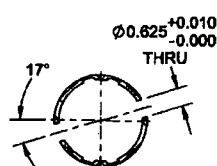
DETAIL M
SCALE 2X



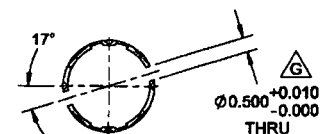
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL

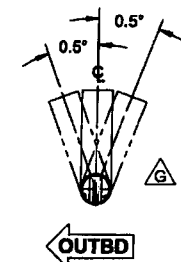
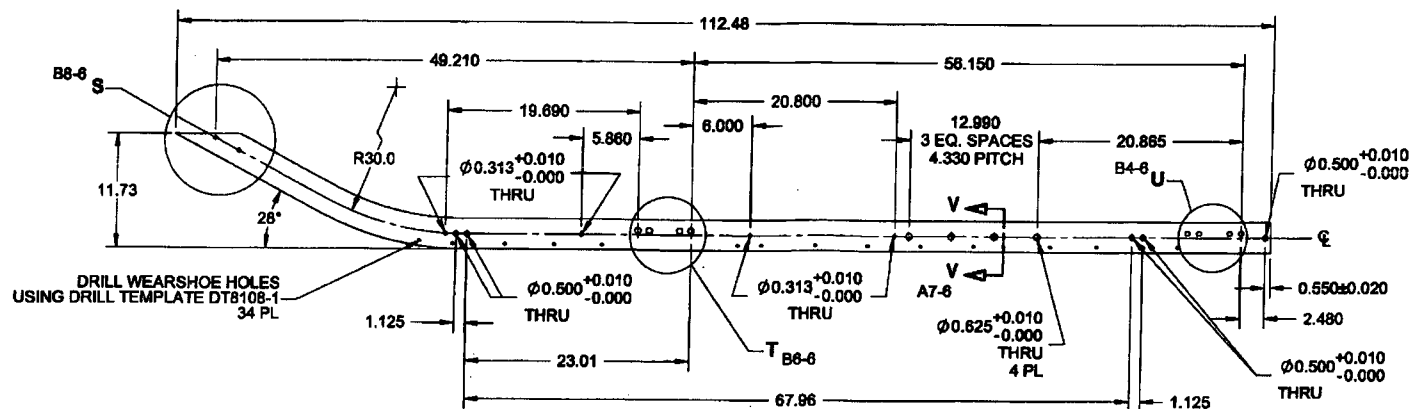


SECTION R-R
SCALE 3X, 4 PL

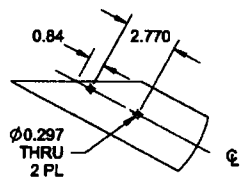
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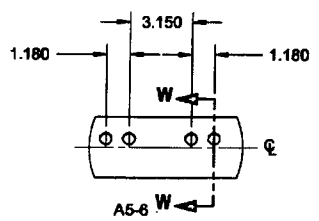
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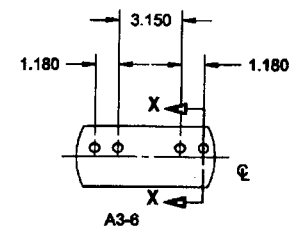
D2750-3 LH SKIDTUBE



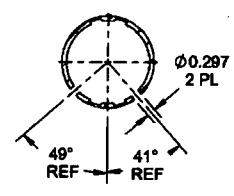
DETAIL S
D8-6
SCALE 2X



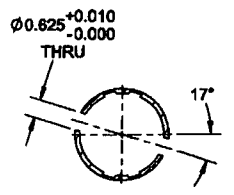
DETAIL T
C5-6
SCALE 2X



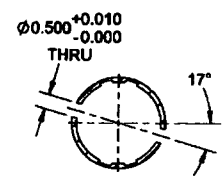
DETAIL U
D3-6
SCALE 2X



SECTION V-V
C4-6
SCALE 3X, 17 PL



SECTION W-W
B8-6
SCALE 3X, 4 PL

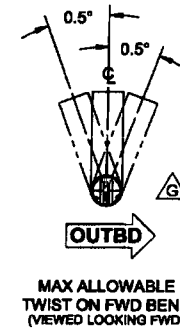
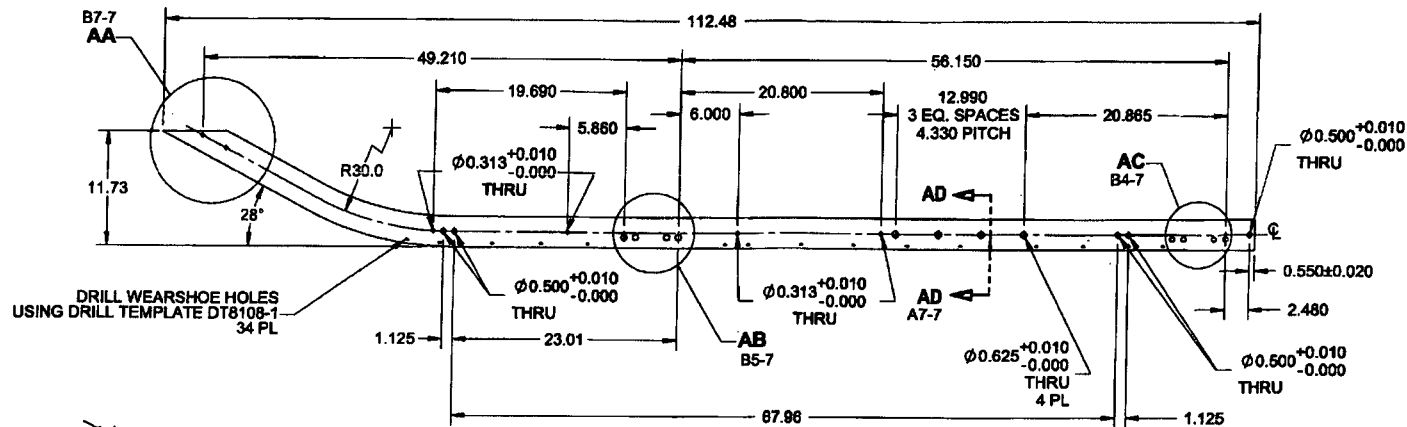


SECTION X-X
B4-6
SCALE 3X, 4 PL

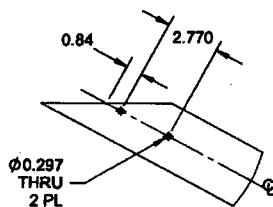
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2013-08-13

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APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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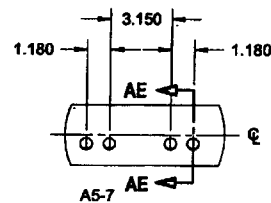
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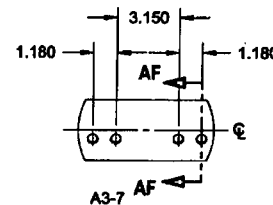
D2750-4 RH SKIDTUBE



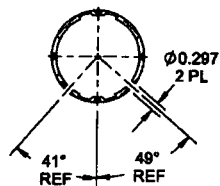
DETAIL AA
D7-7
SCALE 2X



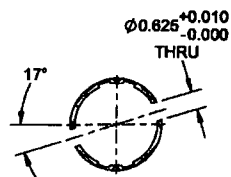
DETAIL AB
C4-7
SCALE 2X



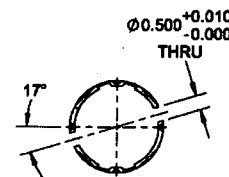
DETAIL AC
D3-7
SCALE 2X



SECTION AD-AD
D3-7
SCALE 3X, 17 PL



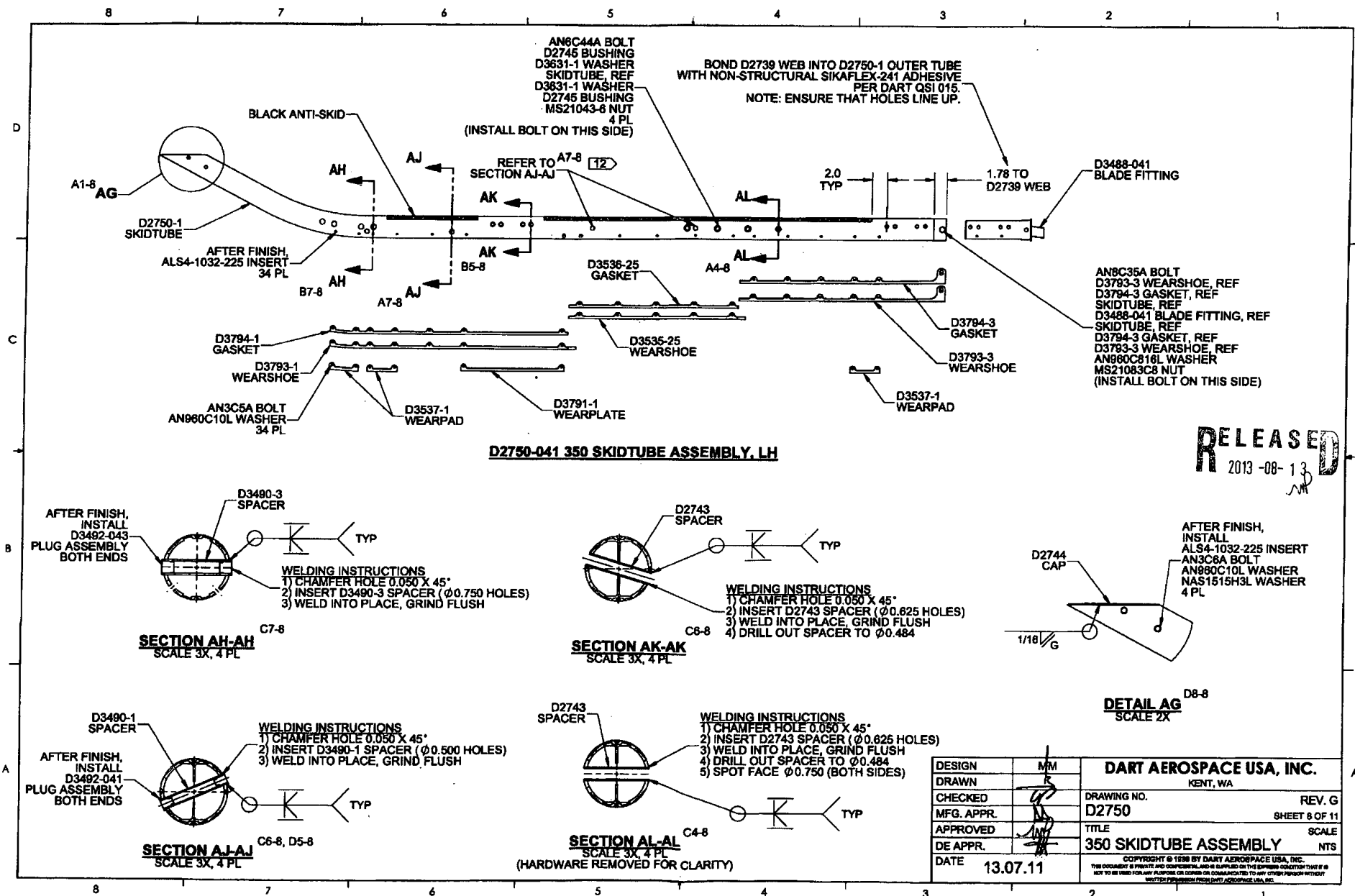
SECTION AE-AE
B6-7
SCALE 3X, 4 PL



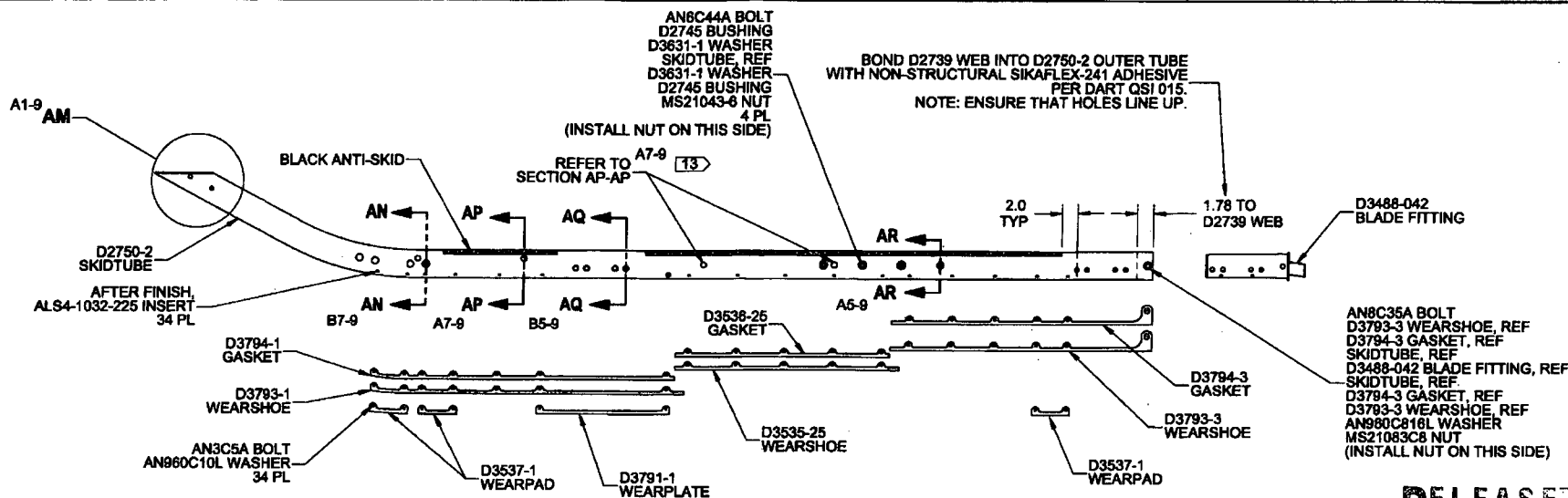
SECTION AF-AF
B4-7
SCALE 3X, 4 PL

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MFG. APPR.		D2750	SHEET 7 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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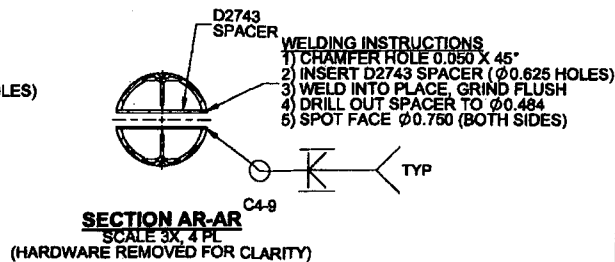
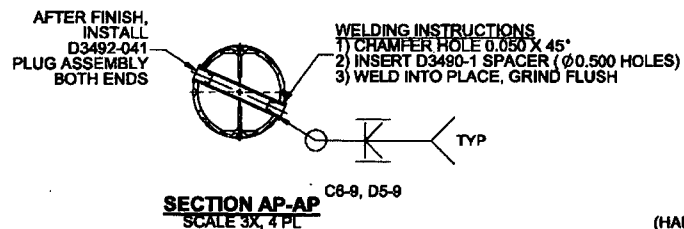
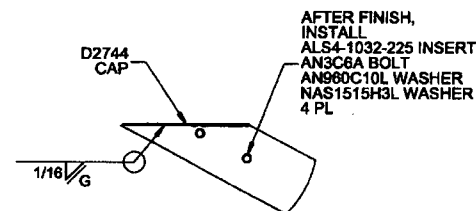
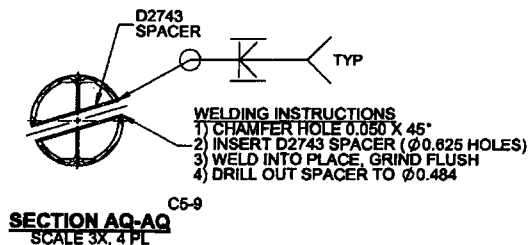
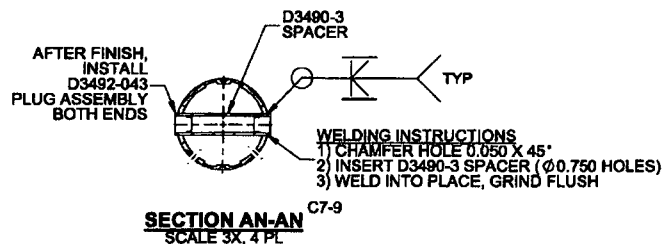


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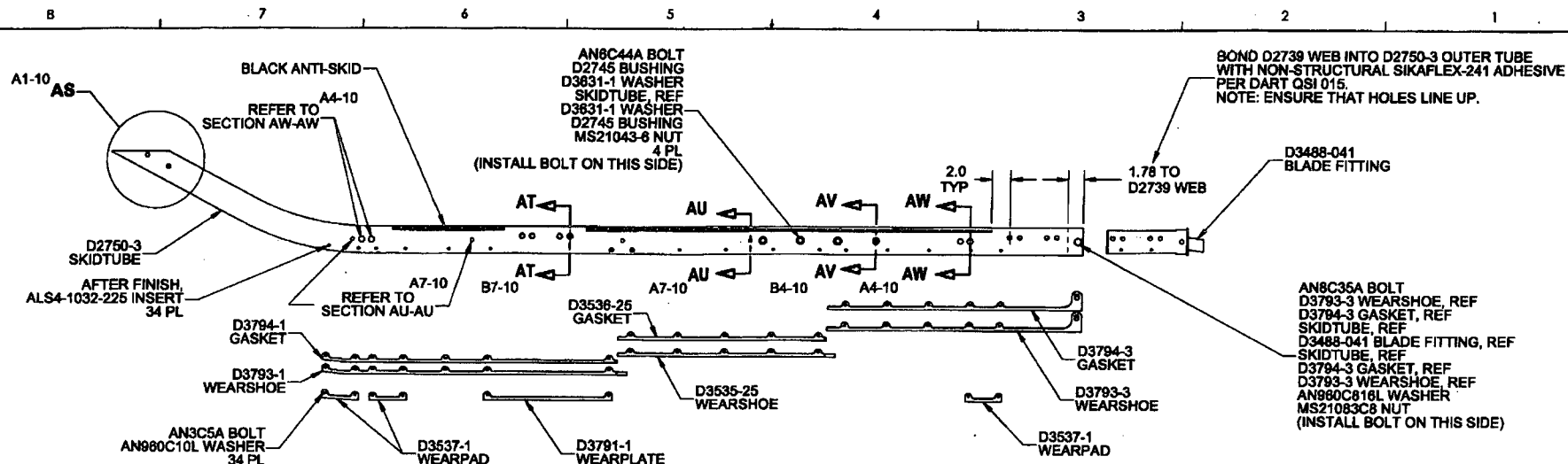
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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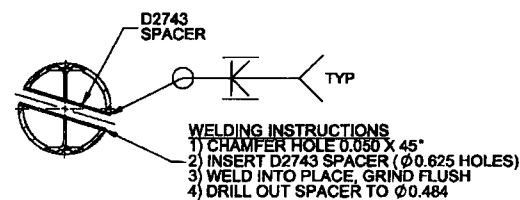
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DATE	13.07.11	350 SKIDTUBE ASSEMBLY
		SCALE NTS

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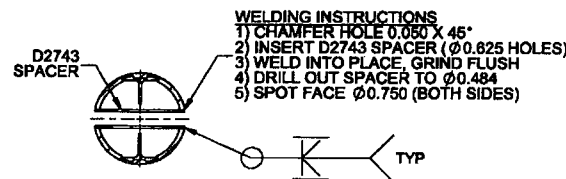


D2750-043 350 SKIDTUBE ASSEMBLY, LH

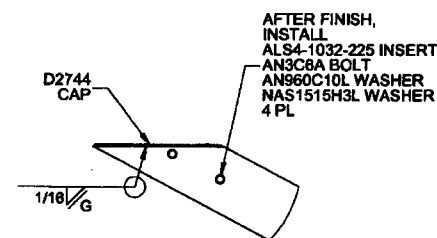
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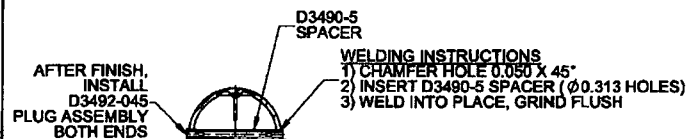
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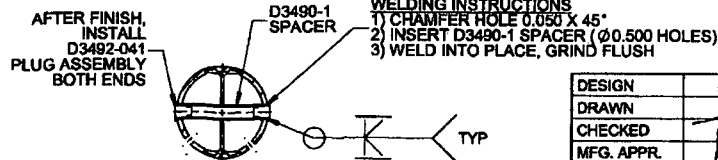
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(HARDWARE REMOVED FOR CLARITY)



DETAIL AS
SCALE 2X



SECTION AU-AU
SCALE 3X, 4 PL

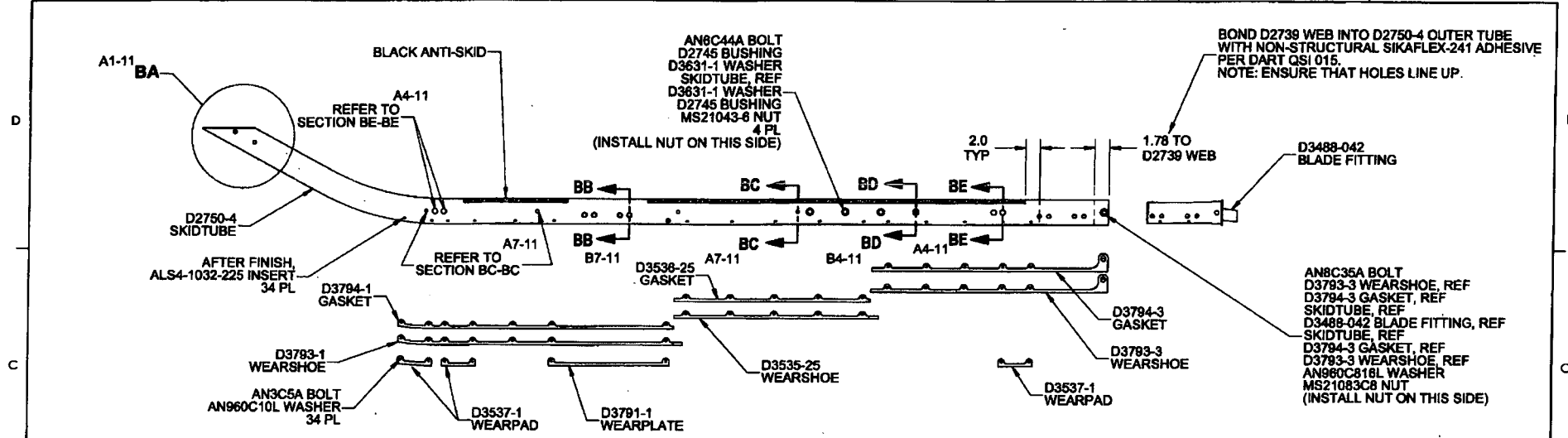


SECTION AW-AW
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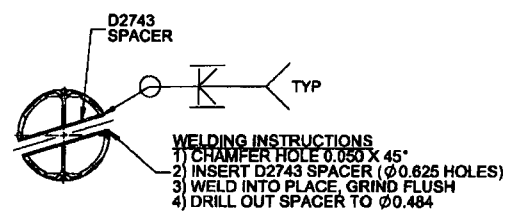
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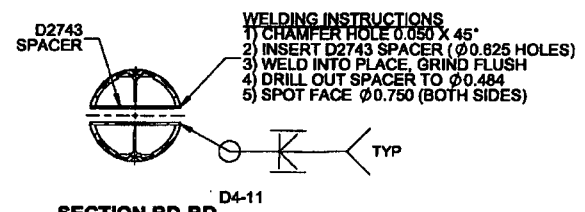
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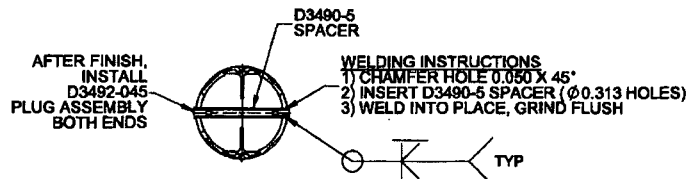
D2750-044 350 SKIDTUBE ASSEMBLY, RH



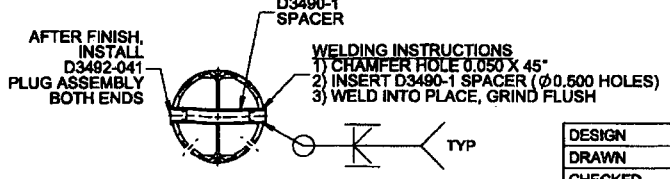
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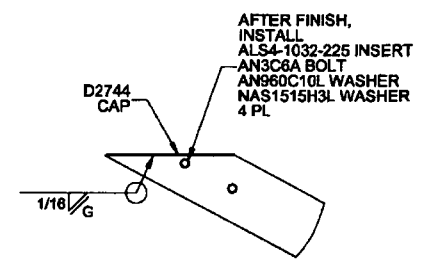
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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